

Work Order ID 55018

January 5, 2010 12:58:36 PM



Page 1

Item ID: D2666-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, LH Fwd Aft In 206

Start Date: 05/01/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *PL*

Date: 10-1-05

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2666

Rev D

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program batch number. 1- Inspect part number and batch number are programmed correctly. 2- Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 3- Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet

MMF

10/01/21

6 1

FTO

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

MMF

10/01/22

6 2

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

MMF

10/01/22

6 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 2666-1 PAR #: _____ Fault Category: Machined parts NCR: Yes No DQA: / Date: 10-01-28
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: / Date: 10-01-28

NCR: <u>55018</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/01/21</u>	<u>#100</u>	<u>face mill at first app was too low because of offset from other job and I did not see it, Not enough material to finish part</u> <u>QC, operator error / LOA</u>	<u>[Signature]</u>	<u>scrap & replace x 1</u> <u>B 46409 x 1</u>	<u>MMF</u> <u>10/01/21</u>	<u>S</u> <u>10/01/22</u>	<u>[Signature]</u> <u>OK 10/01/22</u>	<u>S</u> <u>10/01/22</u>

NOTE: Date & initial all entries

Work Order ID 55018

January 5, 2010 12:58:36 PM



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Item ID: D2666-1

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Setup Start



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Stop



Item Name: Saddle, LH Fwd Aft In 206

Start Date: 05/01/2010 Start Qty: 6.00



Cust Item ID:

Revised Date: 15/01/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



mk 10/01/22

6 0

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QS1005 4.1

0.00

7 10/01/25

X6 0



HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum

0.00

1113170

=> 10/01/26

X6 0



Powdercoat

Memo

0.00

Powder Coating

START TIME: 7:00AM OVEN TEMPERATURE:
FINISH TIME: 3:20PM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55018

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January 5, 2010 12:58:36 PM

Item ID: D2666-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, LH Fwd Aft In 206

Start Date: 05/01/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

PR 10-01-26

⑥

P



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location 426

0.00

10-1-27

②P



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

10/01/27
MF 10-1-27

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 12:58:40 PM

Work Order ID: 55018



Parent Item: D2666-1



Parent Item Name: Saddle, LH Fwd Aft In 206

Start Date: 05/01/2010

Required Date: 15/01/2010

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	26.0000	6.0000			

Saddle Billet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

46409

26

26

mrf

10/01/21

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 55018
Description: 206 Saddle, Inboard, Left side	Part Number: D2666-1
Inspection Dwg: D2666 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	5
A	0.100	0.140		.106	.106	.106	.107		.107
B	0.100	0.140		.110	.110	.111	.111		.111
C	2.470	2.510		2.490	2.490	2.490	2.470		2.490
D	0.100	0.180		.120	.125	.125	.123		.124
E	0.210	0.230		.223	.222	.225	.223		.223
F	1.313	1.343		1.332	1.328	1.327	1.330		1.329
G	0.240	0.260		.247	.247	.247	.248		.248
H	0.615	0.685		.638	.637	.640	.634		.634
I	1.125	1.145		1.138	1.137	1.143	1.135		1.135
J	0.990	1.010			1.001	1.001	1.003		1.003
K	0.235	0.240			.236	.236	.235		.235
L	0.510	0.515			.510	.510	.510		.510
M	0.100	0.120		.111	.111	.111	.110		.110
N	1.565	1.585		1.571	1.574	1.580	1.586		1.575
O	5.990	6.010		6.000	6.002	6.002	6.001		6.001
P	1.245	1.255		1.252	1.250	1.250	1.247		1.247
Q	2.495	2.505		2.498	2.500	2.500	2.499		2.500
R	0.490	0.510		.500	.500	.504	.499		.500
S	0.313	0.318		.315	.315	.315	.315		.315
T	2.495	2.505		2.498	2.500	2.499	2.500		2.499
U	1.357	1.367		1.357	1.359	1.361	1.362		1.361
V	0.315	0.322		.318	.317	.317	.317		.317
W	0.540	0.560		.551	.548	.550	.550		.550
X	1.674	1.684		1.680	1.678	1.680	1.680		1.680
Y	0.257	0.262		.260	.260	.260	.260		.260
Z	0.178	0.198		.188	.188	.188	.188		.188
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: MJE
Date: 10/01/22

Audited by: [Signature]
Date: 10/01/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 55018
Description: 206 Saddle, Inboard, Left side		Part Number: D2666-1
Inspection Dwg: D2666 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance		6	7	Drawing Tol	6	7
A	.100	.140	.107	.107	X	1.674	1.680
B	.100	.140	.112	.112	Y	.257	.260
C	2.470	2.510	2.490	2.490	Z	.178	.188
D	.100	.180	.135	.130			
E	.210	.230	.226	.226			
F	1.313	1.343	1.329	1.330			
G	.240	.260	.250	.250			
H	.615	.625	.638	.645			
I	1.125	1.145	1.137	1.137			
J	.990	1.010	1.007	1.003			
K	.235	.240	.235	.236			
L	.510	.515	.510	.510			
M	.100	.120	.110	.110			
N	1.565	1.585	1.577	1.577			
O	5.990	6.010	6.001	6.003			
P	1.245	1.255	1.250	1.250			
Q	2.495	2.505	2.501	2.501			
R	.490	.510	.497	.499			
S	.313	.318	.315	.315			
T	2.495	2.505	2.500	2.500			
U	1.357	1.367	1.361	1.361			
V	.315	.322	.317	.317			
W	.540	.560	.550	.550			

Measured by: MME	Audited by: [Signature]	Prototype Approval: N/A
Date: 10/01/22	Date: 10/01/22	Date: N/A

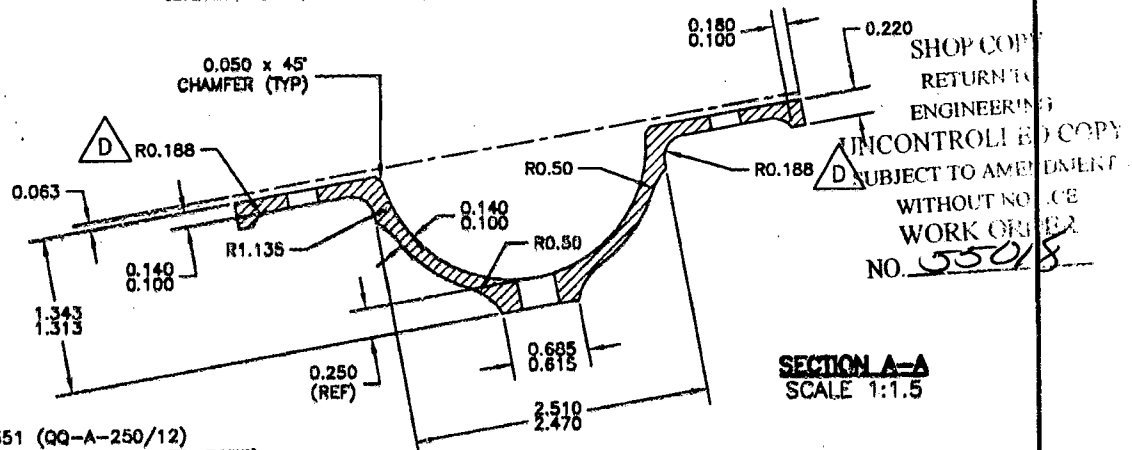
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



DESIGN	<i>A</i>	DRAWN BY	<i>CB</i>	DART AEROSPACE USA, INC.
				PORT HADLOCK, WA
CHECKED	<i>PH</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2666
				REV. D SHEET 1 OF 1
DATE	06.11.08	TITLE	SADDLE FWD INSIDE HIGH	SCALE 1:3
A	97.03.25	NEW ISSUE		
B	97.07.11	ANGLE AND NOTES ADDED		
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095		
D	06.11.08	RO.188 WAS RO.30; Ø0.316 WAS Ø0.313		

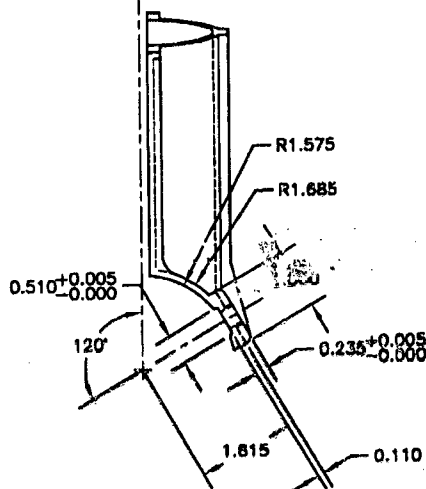
RELEASED

07 02.12 *[Signature]*

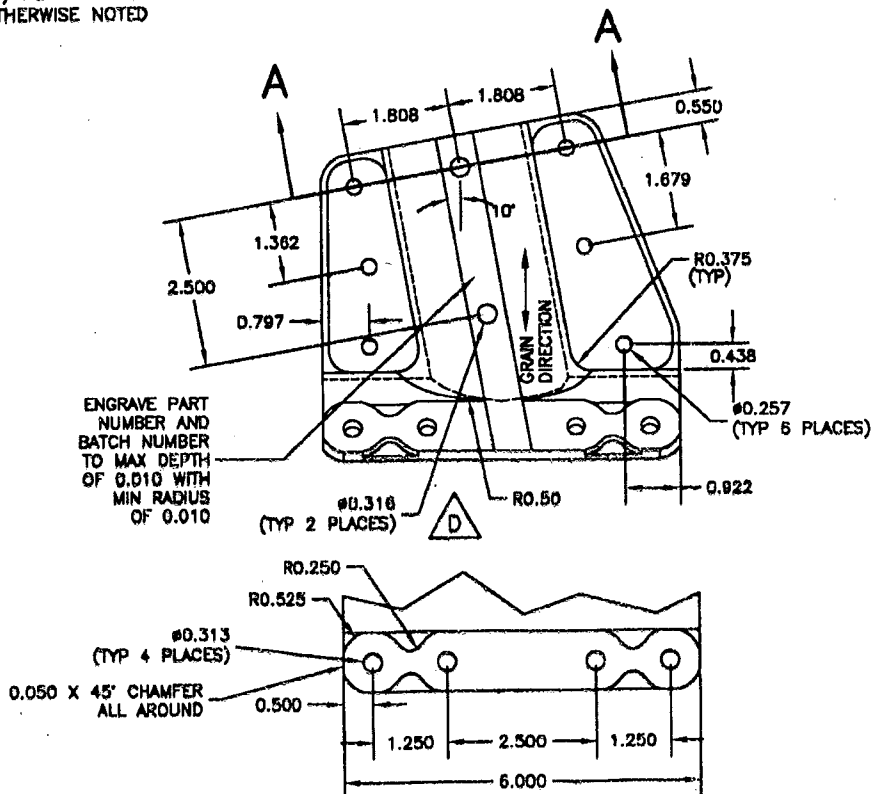


NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12) (MAKE FROM D8101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



D2666-1 SADDLE FWD INSIDE HIGH



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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